

5/42

DART AEROSPACE LTD	Work Order:	24336
Description: Seal	Part Number:	D3117-1
RF 04.11.29 Dwg: D3117 Rev. A b C +F as. 6.04	Qty:	500
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	GH	05.09.26	500
2	PG	Issue P/O 2008732 D3117-1 Seal as per Dwg D3117 Possible Supplier: VIP Rubber Replace Premier P/N: B45-43000-01 Material release note required	AB	05/10/04	500
3	RG	Receive and inspect for transit damage Ensure material release note is attached	CD	05/12/13	518
4	QC6	Inspect dimensions as per Dwg D3117 and certification attached.	Z	05.12.13	818
5	PG	Issue P/O: Cut Qty 3 sample 12" long of D3117-1 Send for testing to meet vertical burn test per F.A.R. 25.853 Possible testing site: Bodycote Materials Testing Canada Inc. Test report is required	Not applicable see attached Email		
6	RG	Attach test report to W/O			
7	ST	Identify and Stock Loc 337 + 346	CD	05/12/14	518 FT
8	AC	Cost / part	SAR	05.12.15	518
9	DC	Close W/O Inspect Level 21	(P)	05/12/15	518

Rev	Date	Change	Revised By	Approved
A	03.01.22	New issue	KJ/RF	JF

RELEASED
03.01.23 ~~PF~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

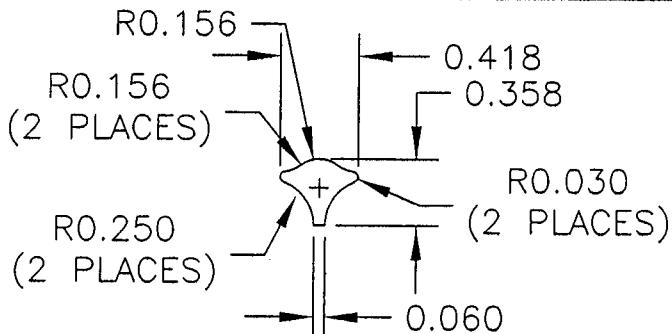
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



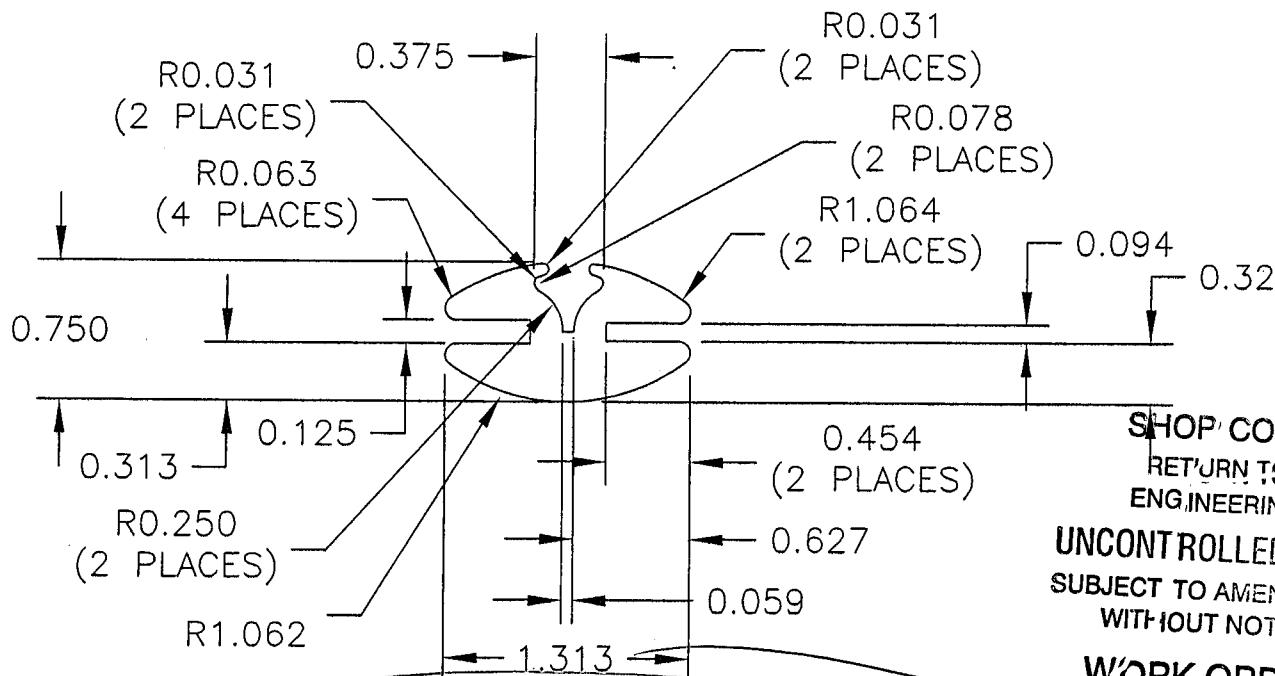
DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3117	REV. C SHEET 1 OF 1
DATE 05.10.03		TITLE SEAL	SCALE 1:1
		A 02.04.15 NEW ISSUE	
		B 04.10.18 UPDATES NOTES	
		C 05.10.03 50 DUROMETER WAS 60 DUROMETER	



RELEASED

05.10.03

D3117-3-XXXX SEAL FILLER
REPLACES PREMIER P/N B45-43000-03



SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. *24336*

NOTES

- 1) -XXXX = LENGTH IN INCHES (EG.10" LONG = -0100, 87.5" LONG = -0875)
- 2) MATERIAL: BLACK RUBBER 50 DUROMETER (HARDNESS) NEOPRENE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
HawkesburySep 26, 2005
10:48 am

Work Order No : 0024336
 Project Name : D3117-1
 Project For : WK542
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3117-1
 Description : Seal Retainer
 Manufactured : Yes
 Amount Req'd : 500
 Amount Done : 0
 Start Date : 09-26-05
 Est Finish Date : 10-12-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00		
<hr/>					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

Stock order
EXTRUDED AND MOLDED RUBBER • EXTRUDED PL
540 S. CYPRESS STREET, LA HABRA, CA 90631
(310) 905-3456 • (800) 722-4VIP
Fax: (310) 905-3460

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY ONTARIO, CANADA
K6A1K7 613-632-9577

ITEM NO.
RE-7107-1897-0156
CUSTOMER P.O.
2008732

CERTIFICATION
OF COMPLIANCE

SHIPPER NO.

48151

THIS IS TO CERTIFY THAT
THE MATERIAL FURNISHED
ON THIS PURCHASE ORDER
WAS MADE IN STRICT
CONFORMANCE WITH THE
NOTED SPECIFICATION.

PART NO./DESCRIPTION	QUANTITY ORDERED
P/N D3117-1 REV C RETAINER	500 FT
P/N D3117-3 REV C FILLER	500 FT
(DWG. #D3117 REV C)	

CURE DATE

4Q05

SPECIFICATION

50/NEOPRENE FORMULATED TO MEET THE FLAME
RESISTANCE TEST OF FAR 25.853a

By

Bernard J. Vipond
President

VIP RUBBER COMPANY

J

DATE SHIPPED 12/1/05
QTY SHIPPED 513'

513'

Linda Lacelle

From: David Shepherd [davids@dartaero.com]
Sent: Wednesday, December 14, 2005 11:45 AM
To: Linda Lacelle
Cc: Jean-Luc Menard
Subject: Re: D3117

For some reason, Premier had put a note on their drawing to test every batch of this stuff. So when we created our drawing, we did the same. However, we now have our own STC for this product and at Rev. C, the note about testing every batch has been removed. Therefore, you DON'T need to send to Bodycote for burn testing. JL should remove this requirement if it is still on the IPP.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>
To: "*David Shepherd (E-mail)" <davids@dartaero.com>; "*Roberto Fuentes
(E-mail)" <robertof@dartaero.com>
Sent: Wednesday, December 14, 2005 5:26 AM
Subject: D3117

>
> Hi,
> The w/o's for D3117-1 / -3 are asking to issue a P.O to Bodycote fo a burn
> test ??? Isn't this done just once? Should this still be on the IPP ?
> LL
>
>